

Work Order ID 119877

May-28-14 9:51:05 AM

119877

Page 1

Item ID: D4910-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Chaffing Shield

Start Date: 5/28/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/28/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MCS Date: 14-05-28 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4910	A
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100

SHEAR

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

DAS

46

9-89

14/08/06

DAS

46

9-89

14/08/06

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Page 2

Item ID: D4910-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Chaffing Shield

Start Date: 5/28/14

Start Qty: 6.00

6

Cust Item ID:

Required Date: 5/28/14

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

6

DAS
38
9-8

14/08/02

130

Small Fab

0.00

130

Small Fab

Memo

0.00

Small Fab

1- Roll as per Dwg
2- Apply a thin coat of proseal as per dwg and let cure.

DAS
30
9-89

6

14/08/12

130090 exp 4/15 6 CR 14/08/26

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

6

DAS
38
9-89

14-9-2

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Item ID: D4910-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Chaffing Shield
 Start Date: 5/28/14 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 5/28/14 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>LG 53</u>	0.00							DAS 41 9-89
150						6			
Packaging	Memo	0.00							14-9-3
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-09-03
 MLJ 14-09-03

Picklist Print

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Work Order ID: 119877

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Parent Item: D4910-1

D4910-1

Parent Item Name: Chaffing Shield

Start Date: 5/28/14

Required Date: 5/28/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.08.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	0.0000	0.35	3		DAS	
M304S25GA									**	2.4		46	17/08/06
304/316 .020" Sheet												9-89	

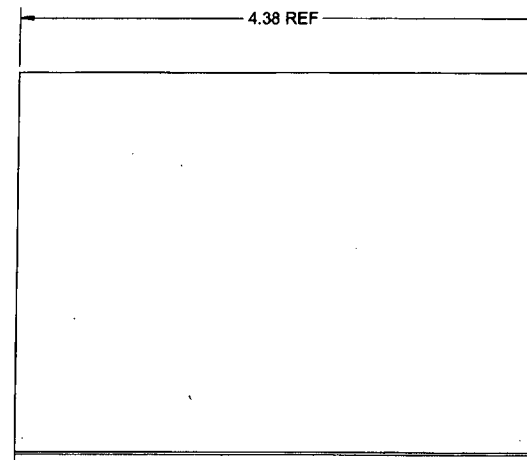
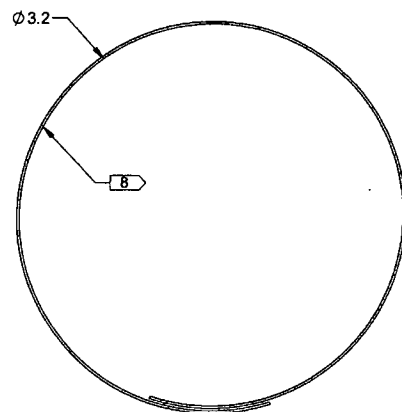
24 GA

14/6/9



3# 125771

125771





D4910-1 CHAFING SHIELD

NOTES:

- 1) MATERIAL: MAKE FROM D4910-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.28 lbs
- 8) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D4910-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS.

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 119877 MLS
14-05-28

RELEASED
2013-08-14
mp

A		NEW ISSUE		CP	13.04.24
REV.		DESCRIPTION		BY	DATE
DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
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